

**Amendments to the Claims:**

Please amend the claims as follows:

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6. (amended) Apparatus for a combined lithographic/flexographic printing process comprising:

a plurality of successive printing stations for printing color images on a substrate in a continuous in-line process;

one of said printing stations comprising a first offset lithographic printing station printing an image using the lithographic process;

one of said printing stations comprising a first offset flexographic printing station, downstream of the first offset lithographic printing station, printing an aqueous-based vehicle image using the flexographic process to form a metallic coating;

a suspended metallic material being included in said aqueous-based vehicle image; and

at least one of the successive printing stations comprising [an offset] a second offset lithographic printing station printing a color image over the aqueous-based vehicle image using the offset lithographic process in said continuous in-line process.

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10. (amended) Apparatus for creating a combined lithographic/flexographic printing process comprising:

a plurality of successive printing stations for printing color images on a substrate in a continuous in-line process;

one of said stations comprising a first flexographic printing station for printing a first color image using the flexographic process;

one of said stations downstream of the first flexographic printing station comprising a second flexographic printing station for printing or coating the substrate using the flexographic process;

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at least one of the successive printing stations comprising an offset lithographic printing station for printing a second color image over the first color image using the offset lithographic process in said continuous in-line process.

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15. (twice amended) Apparatus for a combined lithographic/flexographic printing process comprising:

a plurality of successive printing stations for printing color images on a substrate in a continuous in-line process, said printing stations including both lithographic and flexographic printing stations;

one of said printing stations comprising a first flexographic printing station;

one of said printing stations comprising a first lithographic printing station;

a blanket cylinder at [at least a first one of] said first flexographic printing station

[stations];

an impression cylinder associated with at least said first one of said flexographic printing stations;

flexographic ink-providing means at said [at least] first [one of said] flexographic printing station [stations] for applying a flexographic ink to said blanket cylinder to form an image;

a substrate for receiving said flexographic ink image transferred from said blanket cylinder; [and]

[at least one subsequent] a second lithographic printing station in said in-line process for receiving said image printed substrate and printing an additional colored ink image on said substrate on top of said flexographic ink image using offset lithography; and

a second flexographic printing station.

16. (amended) Apparatus as in claim 15 further comprising:

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a plate cylinder at said [at least first one of said] first flexographic [stations] station;  
a flexographic plate on said plate cylinder for receiving and transferring said flexographic  
ink to said blanket cylinder; and  
said flexographic ink-providing means including a flexographic ink supply and an anilox  
roller associated with said flexographic ink supply for transferring said flexographic ink to said  
flexographic plate.

17. (amended) Apparatus for a combined lithographic/flexographic printing process for printing  
a multicolored image comprising:

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a plurality of successive printing stations for printing color on a substrate in a continuous  
in-line process, said printing stations including both lithographic and flexographic printing  
stations;

[at least] one of said flexographic printing stations being a first flexographic printing  
station having:

(1) a plate cylinder and a blanket cylinder, said plate cylinder including a flexographic  
plate having an image thereon for transferring a flexographic color ink image to said blanket  
cylinder;

(2) an etched anilox roller for applying a flexographic color ink to said flexographic plate  
on said plate cylinder;

(3) an impression cylinder in ink-transfer relationship with said blanket cylinder for  
transferring said flexographic color ink image from said blanket cylinder to said substrate; [and]

at least one of said succeeding printing stations being a lithographic printing station using  
offset lithography for printing additional colored ink images on top of said flexographic ink  
image; and

one of said flexographic printing stations being a second flexographic printing station.

29. (amended) A method of combining lithography and flexographic printing in a continuous in-line process comprising the steps of:

providing a plurality of successive lithographic/flexographic printing stations for printing colored ink images on a substrate;

G 6 printing a flexographic ink image on said substrate at at least a first one of said flexographic stations;

transferring said printed substrate to at least one subsequent lithographic printing station in said continuous in-line process; [and]

printing colored ink images on top of said flexographic ink image at [at least one of] said subsequent lithographic printing [stations] station with an offset lithographic process; and

coating said substrate at a second one of said flexographic stations.

G 7 37. (amended) A method of combining offset lithography and flexographic printing in a continuous in-line process comprising the steps of:

providing a substrate;

applying a flexographic ink to a blanket cylinder in a pattern with a coating head at a first flexographic printing station;

transferring said pattern of flexographic ink from said blanket cylinder to the substrate;

transferring said substrate to a second flexographic printing station;

applying a pattern of flexographic ink to the substrate using the second flexographic printing station;

and

printing a waterless ink pattern over said flexographic ink pattern on said substrate using at least one subsequent offset lithographic printing station in said continuous in-line process.

G 8 38. (amended) A method of combining lithography and flexographic printing in a continuous in-line process comprising the steps of:

printing an aqueous-based vehicle image having suspended particles therein on a substrate at a first flexographic printing station;

transferring said image printed substrate to [at least one additional] a subsequent printing station in said continuous in-line process; [and]

printing additional colored ink images on said printed substrate over said aqueous-based vehicle image in an offset lithographic process at said at least one additional printing station in said in-line process; and

coating over said colored ink images on said substrate using a flexographic process.

Please cancel claims 42-43.

44. (three times amended) Apparatus for a combined lithographic/flexographic printing process comprising:

a substrate;

a plurality of successive printing stations for depositing a series of images on one side of a substrate in a continuous in-line process;

one of said printing stations comprising a first flexographic printing station for printing a first liquid vehicle image on said substrate using a flexographic process; and

one of said printing stations subsequent to the first flexographic printing station comprising a first lithographic printing station;

one of said printing stations subsequent to the first lithographic printing station comprising a second flexographic printing station for printing a second liquid vehicle image on said substrate using a flexographic process; and

one of said printing stations subsequent to the second flexographic printing station comprising a second lithographic printing station;

whereby the second liquid vehicle image is printed on top of at least a portion of that printed at the first lithographic printing station.

46. (three times amended) Apparatus as in claim 44 wherein at least one image deposited by one of the lithographic printing stations comprises ink.

Please cancel claims 49-57.

58. (three times amended) Apparatus for a combined lithographic/flexographic printing process comprising:

a plurality of successive printing stations for depositing a series of images on a substrate in a continuous in-line process, said printing stations including, both lithographic and at least two flexographic printing stations;

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a blanket cylinder at at least a first one of said flexographic printing stations;  
flexographic ink-providing means for applying a flexographic ink to said blanket cylinder to form an image on one side of a substrate;

a substrate for receiving said flexographic ink image transferred from said blanket cylinder; and

at least one subsequent lithographic printing station in said in-line process for receiving said image printed substrate and printing an additional colored ink image on said substrate on top of said flexographic ink image.

Please cancel claims 60-81.

82. (Four times Amended) A method of combining lithography and flexographic printing in a continuous in-line process comprising the steps of:

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(1) providing a plurality of successive printing stations for depositing a series of images on a substrate in said in-line continuous process;

(2) utilizing an anilox roller to transfer a liquid ink as one of said series of images to a flexographic plate image at least one of said printing stations;

(3) printing said liquid ink from said flexographic plate image to one side of said substrate;

(4) transferring said printed substrate with said liquid ink image to a subsequent printing station in said inline printing process;

(5) repeating steps (2)-(4) at subsequent printing stations in said in-line process to achieve a desired opacity ink image on the one side of said substrate; and

(6) printing an ink pattern on said substrate using an offset lithographic process.

Please cancel claims 85-151.

- G 13
152. (new) Apparatus for a combined lithographic/flexographic printing process comprising:  
a substrate having a first side and a second side;  
a plurality of successive printing stations for printing color images on the substrate in a  
continuous in-line process, the successive printing stations including:  
    a first lithographic printing station for printing an image on the first side of the substrate  
    using the lithographic process;  
    a first flexographic printing station, subsequent in the continuous in-line process to the  
    first lithographic printing station, for printing an image on the first side of the substrate using the  
    flexographic process;  
    a second lithographic printing station, subsequent in the continuous in-line process to the  
    first flexographic printing station, for printing an image on the first side of the substrate using the  
    lithographic process; and  
    a second flexographic printing station, subsequent in the continuous in-line process to the  
    second lithographic printing station, for printing an image on the first side of the substrate using  
    the flexographic process.

153. (new) Apparatus for a combined lithographic/flexographic printing process comprising:  
a substrate;

a plurality of successive printing stations for printing color images on the substrate in a continuous in-line process, the successive printing stations including:

a first flexographic printing station for printing an image on the first side of the substrate  
using the flexographic process;

a first lithographic printing station, subsequent in the continuous in-line process to the first lithographic printing station, for printing an image on the substrate using the lithographic process;

a second flexographic printing station, subsequent in the continuous in-line process to the first lithographic printing station, for printing an image on the substrate using the flexographic process; and

a second lithographic printing station, subsequent in the continuous in-line process to the second flexographic printing station, for printing an image on the first side of the substrate using the lithographic process.

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154. (new) Apparatus for a combined lithographic/flexographic printing process comprising:  
a substrate;  
a plurality of successive printing stations for printing color images on the substrate in a  
continuous in-line process, the successive printing stations including:  
    a first lithographic printing station;  
    a first flexographic printing station, subsequent in the continuous in-line process to the  
first lithographic printing station;  
    a first dryer, subsequent in the continuous in-line process to the first flexographic printing  
station;  
    a second lithographic printing station, subsequent in the continuous in-line process to the  
first dryer;  
    a second dryer, subsequent in the continuous in-line process to the second lithographic  
printing station;  
    a second flexographic printing station, subsequent in the continuous in-line process to the  
second dryer; and  
    a third dryer, subsequent in the continuous in-line process to the second flexographic  
printing station.

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155. (new) Apparatus for a combined lithographic/flexographic printing process comprising:  
a substrate;  
a plurality of successive printing stations for printing color images on the substrate in a  
continuous in-line process, the successive printing stations including:  
a first lithographic printing station;  
a first dryer, subsequent in the continuous in-line process to the first lithographic printing  
station;  
a first flexographic printing station, subsequent in the continuous in-line process to the  
first dryer;  
a second dryer, subsequent in the continuous in-line process to the first flexographic  
printing station;  
a second lithographic printing station, subsequent in the continuous in-line process to the  
second dryer;  
a third dryer, subsequent in the continuous in-line process to the second lithographic  
printing station;  
a second flexographic printing station, subsequent in the continuous in-line process to the  
third dryer; and  
a fourth dryer, subsequent in the continuous in-line process to the second flexographic  
printing station.

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156. (new) A method for a combined lithographic/flexographic printing process, the method comprising the steps of:

providing a substrate having a first side and a second side;

printing an image on the first side of the substrate using a first lithographic printing station;

transferring the substrate from the first lithographic printing station to a first flexographic printing station;

printing an image on the first side of the substrate using the first flexographic printing station;

transferring the substrate from the first flexographic printing station to a second lithographic printing station;

printing an image on the first side of the substrate using the second lithographic printing station;

transferring the substrate from the second lithographic printing station to a second flexographic printing station;

printing an image on the first side of the substrate using the second flexographic printing station.

157. (new) A method for a combined lithographic/flexographic printing process, the method comprising the steps of:

providing a substrate;

printing an image on the substrate using a first flexographic printing station;

transferring the substrate from the first flexographic printing station to a first lithographic printing station;

printing an image on the first side of the substrate using the first lithographic printing station;

transferring the substrate from the first lithographic printing station to a second flexographic printing station;

printing an image on the first side of the substrate using the second flexographic printing station;

transferring the substrate from the second flexographic printing station to a second lithographic printing station;

printing an image on the first side of the substrate using the second lithographic printing station.

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158. (new) A method for a combined lithographic/flexographic printing process, the method comprising the steps of:

providing a substrate;

printing an image on the substrate using a first lithographic printing station;

transferring the substrate from the first lithographic printing station to a first flexographic printing station;

printing an image on the substrate using the first flexographic printing station;

transferring the substrate from the first flexographic printing station to a first dryer;

drying the substrate in the first dryer;

transferring the substrate from the first dryer to a second lithographic printing station;

printing an image on the first side of the substrate using the second lithographic printing station;

transferring the substrate from the second lithographic printing station to a second dryer;

drying the substrate in the second dryer;

transferring the substrate from the second dryer to a second flexographic printing station;

printing an image on the substrate using the second flexographic printing station;

transferring the substrate from the second flexographic printing station to a third dryer;

and

drying the substrate in the third dryer.

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